






Work Order ID 65812




Wednesday, January 26, 2011 10:56:27 AM



Page 1


Item ID: D3531-041 Accept  Setup Start 
Revision ID:
Item Name: Bracket Assembly 10 Stop 
Start Date: 1/26/2011 Start Qty: 4.00  Cust Item ID:
Required Date: 2/7/2011 Req'd Qty: 4.00  Customer:

Reference:


Approvals: Process Plan:  Date: 11-01-26 Tooling: _____ Date: _____ Run Start 
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop 

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D3531	Rev A

100		0.00							
	Small Fab								
Small Fab	Memo	0.00							
Small Fab	Assemble as per dwg D3531								

GS 1/02/24 (10)

110		0.00							
	QC5- Inspect part completeness to step on W/O								
QC	Memo	0.00							
Quality Control									

8-1-24 (10)

120		0.00							
	Black Sandtex(Ref:4.3.5.7) per QSI005 4.3								
Powdercoat	Memo	0.00							
Powder Coating	START TIME: 1:30 <input type="checkbox"/> OVEN TEMPERATURE:								
	320° <input type="checkbox"/> FINISH TIME: 2:00								

10 BR 11-2-24

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 65812

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Wednesday, January 26, 2011 10:56:27 AM

Item ID: D3531-041

Accept



Setup Start



Revision ID:

Stop



Item Name: Bracket Assembly

Start Date: 1/26/2011 Start Qty: 4.00



Cust Item ID:

Required Date: 2/7/2011 Req'd Qty: 4.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 QC Quality Control	QC3- Inspect Part Finish Memo	0.00 0.00				10	0	11/02/25	
140 Packaging Packaging	Identify as per dwg & Stock Location: <u>228</u> Memo	0.00 0.00							
150 QC Quality Control	QC21- Final Inspection - Work Order Release Memo	0.00 0.00							

CF 11/03/01

W/O:		WORK ORDER CHANGES					
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NOTE: Date & initial all entries

Picklist Print

Wednesday, January 26, 2011 10:56:32 AM

Page 1

Work Order ID: 65812

Parent Item: D3531-041

Parent Item Name: Bracket Assembly




Start Date: 1/26/2011

Required Date: 2/7/2011

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP Rev:A New Issue 07-09-24 EC verified DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3531-1  Bracket		Manufactured	No			100	Each	3.0000	1	4			
<div> <div>Location</div> <div>st238</div> <div>64115</div> </div> <div> <div>Loc Qty</div> <div>3</div> <div>3</div> </div> <div> <div>Loc Code</div> <div></div> <div></div> </div>													
D3531-3  Bracket Front Plate		Manufactured	No			100	Each	2.0000	1	4			
<div> <div>Location</div> <div>ST031</div> <div>64116</div> <div>ST068</div> <div>61781</div> </div> <div> <div>Loc Qty</div> <div>1</div> <div>1</div> <div>1</div> <div>1</div> </div> <div> <div>Loc Code</div> <div></div> <div></div> <div></div> <div></div> </div>													
MS20470AD4-4  Rivet, Universal Head		Purchased	No			100	Each	4,926.000	12	48			
<div> <div>Location</div> <div>ST319</div> <div>112314</div> <div>113368</div> <div>116188</div> <div>116391</div> </div> <div> <div>Loc Qty</div> <div>4926</div> <div>30</div> <div>92</div> <div>1168</div> <div>3636</div> </div> <div> <div>Loc Code</div> <div></div> <div></div> <div></div> <div></div> <div></div> </div>													

JS 11/02/23
B66235 (7x)

JS 11/02/23
B66239 (9x)

JS 11/02/23
120

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

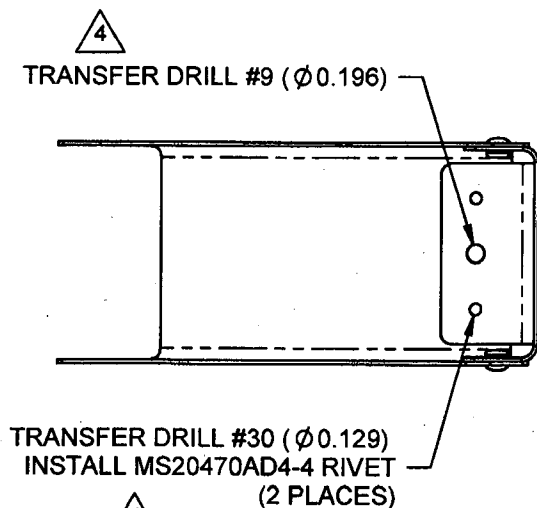
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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

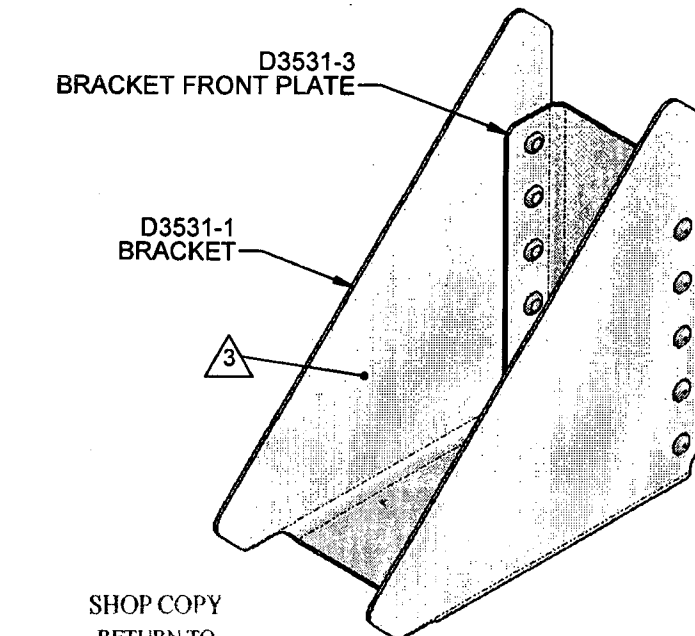
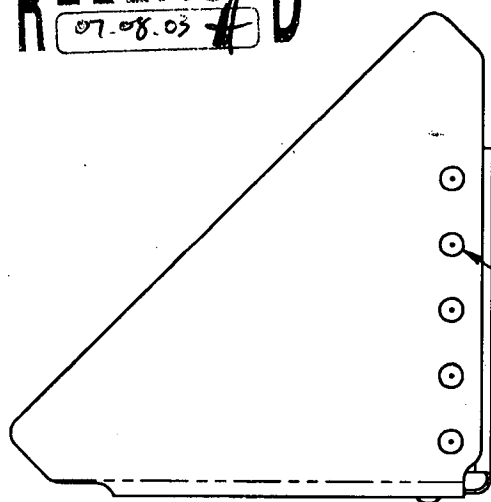
NOTE: Date & initial all entries



DESIGN CB	DRAWN BY CB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED LE	APPROVED A	DRAWING NO. D3531	REV. A SHEET 1 OF 3
DATE 07.06.19	TITLE BRACKET ASSEMBLY		SCALE 1:2
REV A	DATE 07.06.19	DESCRIPTION NEW ISSUE	

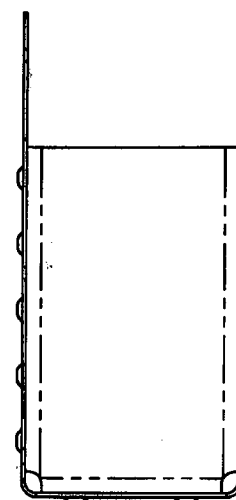


RELEASED
07.08.03



SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. **65812**
211-01-26

MS20470AD4-4
(10 PLACES)



D3531-041 BRACKET ASSEMBLY

NOTES:

- 1) FINISH: POWDER COAT ASSEMBLY BLACK
SANDTEX (4.3.5.7) PER DART QSI 005 4.3
ALL PARTS
- 2) ASSEMBLE PER DART QSI 003
- 3) IDENTIFY WITH DART P/N "D3531-041" USING
WHITE MARKER ON INSIDE OF BRACKET
ASSEMBLY, WHERE INDICATED
- 4) TRANSFER DRILL HOLES FROM D3531-1 BRACKET
THROUGH D3531-3 BRACKET FRONT PLATE
BEFORE FINISHING

PARTS LIST

QTY.	P/N	DESCRIPTION
X	D3531-041	BRACKET ASSEMBLY
1	D3531-1	BRACKET
1	D3531-3	BRACKET FRONT PLATE
12	MS20470AD4-4	RIVET

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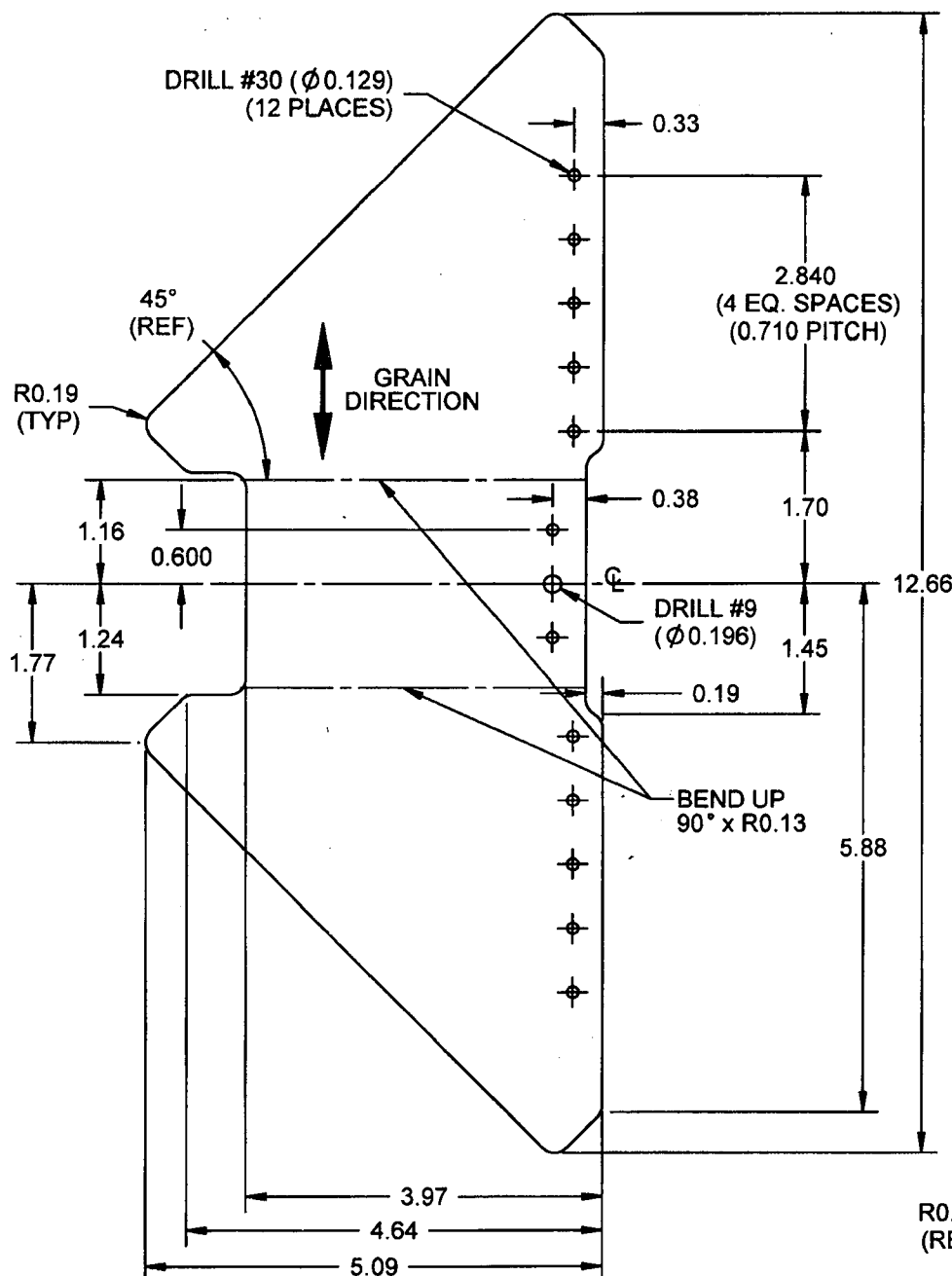
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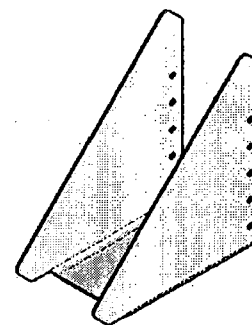
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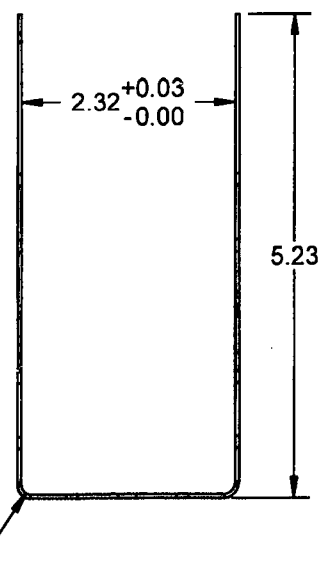
DESIGN CB	DRAWN BY CB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED LE	APPROVED A	DRAWING NO. D3531	REV. A
DATE 07.06.19	TITLE BRACKET ASSEMBLY		SHEET 2 OF 3 SCALE 1:2



D3531-1F FLAT PATTERN



RELEASED
07-08-03



D3531-1 BRACKET

NOTES:

- 1) MATERIAL: ALUMINUM 6061-T6/T62 SHEET, 0.040 THICK PER QQ-A-250/11 OR AMS 4025 OR AMS 4027 (REF DART SPEC M6061T6S.040).
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 5) BREAK ALL SHARP CORNERS TO 0.010 MAX
- 6) PART IS SYMMETRIC ABOUT ϕ

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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

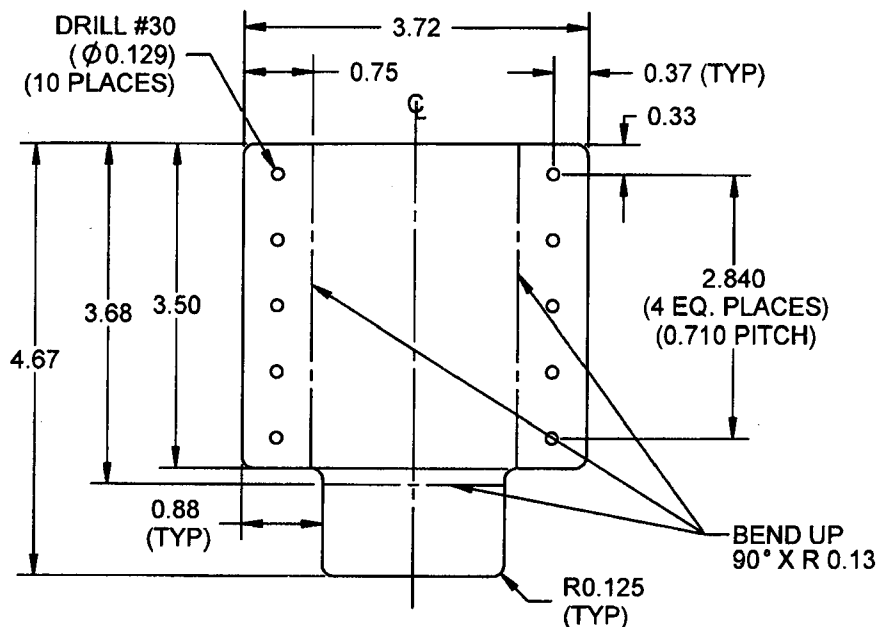
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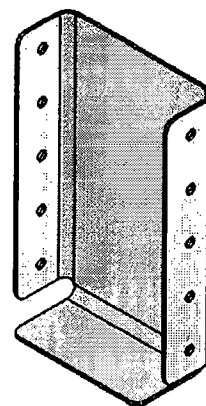


DESIGN CB	DRAWN BY CB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED CE	APPROVED #	DRAWING NO. D3531	REV. A
DATE 07.06.19		TITLE BRACKET ASSEMBLY	SHEET 3 OF 3 SCALE 1:2

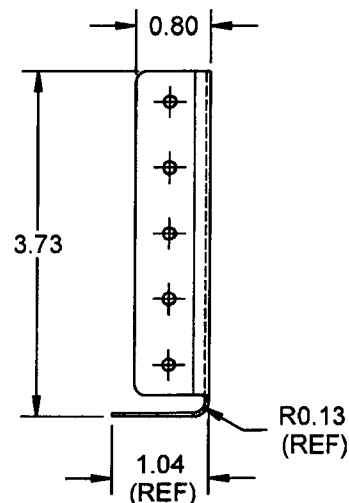
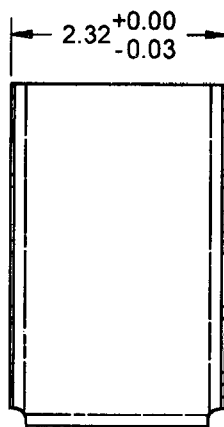


D3531-3F FLAT PATTERN

RELEASED
07.08.03



u/065812



D3531-3 BRACKET FRONT PLATE

NOTES:

- 1) MATERIAL: ALUMINUM 6061-T6/T62 SHEET, 0.040 THICK PER QQ-A-250/11 OR AMS 4025 OR AMS 4027 (REF DART SPEC M6061T6S.040)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 5) BREAK ALL SHARP CORNERS TO 0.010 MAX
- 6) PART IS SYMMETRIC ABOUT ϕ

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NOTE: Date & initial all entries